

28

Date: Tuesday, 6/19/2007 4:41:49 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FUEL PURGE CANISTER INSTALLATION
Job Number : 33018
Estimate Number : 10856
P.O. Number : N/A Part Number : D412706011
This Issue : 6/19/2007 S.O. No. : Drawing Number : N/A
Prsht Rev. : NC Project Number : N/A
First Issue : MA Type : LARGE FAB ASSY Drawing Revision : N/A
Previous Run : 32173 Material : N/A
Written By : Due Date : 7/10/2007 Qty: 2 Um: Each
Checked & Approved By : 7/07/06/20
Comment : Est Rev: 04.12.03 Remove AN6289-6D; Change Qty of AN924-6D KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



KJ 07.06.20

Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D412-706-011CHG001

o86ulco

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0 D20014 Valve 1/4"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty	Part Number	Description	Batch
1	D2001-4	Valve Assembly	32197

AS

(X2)

4.0 D3262041 Fuel Purge Canister



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty	Part Number	Description	Batch
1	D3262-041	Canister Assembly	33065

AS

(X2)

5.0 D32641 Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	D3264-1	Bracket	B34243

C 8/01/10 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Description :

6.0

D329710098

HOSE ASS'Y



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3297-1-0098 Hose Assembly

23286

AS

(X2)

7.0

D329730085

HOSE ASS'Y



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3297-3-0085 Hose Assembly

23289

AS

(X2)

8.0

D329730210

HOSE ASS'Y



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3297-3-0210 Hose Assembly

23290

AS

(X2)

9.0

D3298001

Tube Assembly 25"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3298-001 Tube Assembly

33067

AS

(X2)

10.0

D3298003

Tube Assembly 27"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3298-003 Tube Assembly

23294

AS

(X2)

11.0

D3298005

Tube Assembly 23"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3298-005 Tube Assembly

23295

AS

8/1/20

(X2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Machine Or Operation:

Description :

12.0

D3298007

Tube Assembly 8"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3298-007

Fitting

B23296

AS

(X2)

13.0

D3298009

Tube Assembly 6"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3298-009 Tube Assembly

35137

AS

(X2)

14.0

D32991

Fitting



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3299-1

Fitting

B35138

AS

(X2)

15.0

D32993

Fitting



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3299-3

Fitting

B29560

AS

(X2)

16.0

D32995

Fitting



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

1 D3299-5

Fitting

B23303

AS

(X2)

17.0

D33011

PLACARD



B23304

AS



(X2)

Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3302-1

Doubler

8/1/10

D3301-1

B23304

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Part Number: D412706011

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

D33013

PLACARD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3301-3

Placard

B23305

AS

(X2)

19.0

D33021

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3302-1

Doubler

35129

AS

(X2)

20.0

D33023

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3302-3

Doubler

B34245

AS

(X2)

21.0

D33291

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D3329-1

Bushing

22056

AS

(X2)

22.0

AN35A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

4 AN3-5A

Bolt

M19356

AS

(X2)

23.0

AN8146D

Plug



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 AN814-6D

Plug

M7710

AS 8/1/10

(X2)

W/O:		WORK ORDER CHANGES					
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Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

AN8156D

Union-M-Flare



Comment: Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

3 AN815-6D

Plug

M17654

AS

(x2)

25.0

AN8326D

UNION



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 AN832-6D

Union

M17654

AS

(x2)

26.0

AN8336D

Elbow, Bulkhead-M-Flare



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

2 AN833-6D

Union

M103691

AS

(x2)

27.0

AN9246D

Nut



Comment: Qty.: 5.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

5 AN924-6D

Nut

M104374

AS

(x2)

28.0

AN9386D

Tee



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 AN938-6D

Tee

M17654

AS

(x2)

29.0

AN960JD10

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

105792

All the same

AS

8/1/10

(x2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 33018

Part Number: D412706011

Job Number:



Seq. #:

Machine Or Operation:

Description :

8 AN960JD10

Washer

30.0

AN960JD10L

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

4 AN960JD10L

Washer

M104374

AS

(x2)

31.0

MS21042L3

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

4 MS21042L3

Nut (or -3)

M105558

AS

(x2)

32.0

MS21919WDG9

Clamp



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

2 MS21919WDG9

Clamp

M105044

AS

(x2)

33.0

MS2192042

CLAMP(per MIL-DTL-8783C)



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

2 MS21920-42

Clamp

M18040

AS

(x2)

34.0

MS287786

Packing



Comment: Qty.: 10.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

10 MS28778-6

O-Ring

M104885

AS

(x2)

35.0

MS3548911

GROMMET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

M16323

AS

08/01/07

(x2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 08/04/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number: 33018

Part Number: D412706011

Job Number:



Seq. #:

Machine Or Operation:

Description :

1 MS35489-11 Grommet

36.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

8/10/10 (2)

37.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-706-011

Location:

PPP Rev:

B

8/1/10 50 (2x)

38.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2
8/10/11

Job Completion



11 0801-11

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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CUSTOMER RETURN

Initiator: Sean Kerr
 Company: Helicopter Transport Canada
C'HTRAOI
 Phone No. 613-839-5868

Date: April 11/08
 Invoice # 6252
 Order Entry # 5790

Reason for return: Kit ordered in error

Attach Copy of DHS Return Authorization # 407

REFERENCE ONLY

Receiving: 8/5/14 Date Received: 8/5/14 Freight Company: GERRY HOUND Prepaid Collect

#	Part #	Batch #	Description	Distribute to QC	
1	D412-706-011	33018	Fuel Purge Connector Kit	Advise QA	Date:
				<u>DAK</u>	<u>8/5/14</u>

Condition of packaging: Good Photograph required: yes ☒ no

Paperwork attached: P/S ☒ Invoice ☐ ARC ☐ Docs ☐ Other ☐

QC:

Quarantine: Location: 2 Condition of Part: All good

Inspect: Initial: 2

#	Part #	Batch #	QC Comments	QC Approval		Scrap
				Initial	W/O #	
1	D412-706-011	33018	Kit complete, return to stock as per W/O	<u>2</u>	<u>39282</u>	

QA Coordinator:

Advise GM as to findings: Initial: _____ Date: _____

Comments:

Issue credit: yes no

GM Approval: _____ Date: _____

Invoice Amount: _____
 Less Replacement: _____
 Restock Fee: _____
 Freight: _____
 Net Credit: _____
 DHS ☐ Customer ☐

QA: Enter into Q-Pulse with reason for return & File original. Signed: _____ Date: _____

Copy of Customer Return to stay with work orders and another copy to be filed with customer credit